

SLIT

Work Order ID 46410-5

June 26, 2009 11:50:58 AM



Item ID: D6101-003
Revision ID: A
Item Name: Saddle Billet, 7075

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 300.00
Required Date: 03/08/2009 Req'd Qty: 300.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D6101

Rev A

100

0.00



Purchasing

PURCHASING

Memo

0.00

Issue P/O: 8393 a) Description: Alluminum billet (b) 7.875" x
6.250" x 2.00" thick c) Tolerance on all dimensions are +0.030"/-0.000" d)
Grain direction along 7.875" length e) Material: 7075-T7351 (QQ-A-
250/12) f) Material certification requi

OK 09/10/23

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Ensure material certification is attached

Rec'd 2/2

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Ensure Material certification comply to Dwg D6101

OK 10/02/04

40

Quality Control

Work Order ID 46410

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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: *MAT*

0.00

Memo

0.00

ent 10/02/04

40

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/04
mtf
10-2-4

Picklist Print

June 26, 2009 11:30:05 AM

Page 1
1

Work Order ID: 46410

Parent Item: D6101-003RevA

Parent Item Name: Saddle Billet, 7075

Comments:



Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 300.00

Required Qty: 300.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003PRevA		Purchased	No			110	Each	0.0000	300.0000			



7075-17351 2X6.25X7.875



ME 10-2-4



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

BLANKET PO REPRINT

Purchase Order ID 8393

Purchase Order Date 6/29/09

PO Print Date 1/18/10

Page Number 1 of 2

Order From :

VC-MET001

METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100
TORONTO, ON M4Y 3A5
CA

FAXED

Contact Name

Vendor Phone 514 694 9575

Vendor Fax 514 695 3281

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms Net 30

Currency CAD

FOB

Ship To :

MAIN WAREHOUSE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6101-001P A	7075-T7351 2X6X6.25	6/29/09 Yes	40 200.00 Each	Yours ppd	\$45.1000	\$9,020.00
Blanket Original Quantity:		200.00	Blanket Remaining Quantity:		0.00		
		Special Inst:	B46409	40	Yours ppd	\$59.1600	\$11,832.00
2	D6101-003P A	7075-T7351 2X6.25X7.875	6/29/09 Yes	40 200.00 Each	Yours ppd	\$59.1600	\$11,832.00
Blanket Original Quantity:		200.00	Blanket Remaining Quantity:		0.00		
		Special Inst:	B46410	40	Yours ppd	\$59.1600	\$11,832.00
3	D6101-005P A	7075-T7351 8.25X5.0X2.5	6/29/09 Yes	250.00 Each		\$61.0000	\$15,250.00
Blanket Original Quantity:		200.00	Blanket Remaining Quantity:		-50.00		
		Special Inst:	B46411	40	Yours ppd	\$59.1600	\$11,832.00
4	D6101-007P A	7075-T7351 8.25X7.75X2.5	6/29/09 Yes	200.00 Each		\$200.0000	\$40,000.00
Blanket Original Quantity:		200.00	Blanket Remaining Quantity:		0.00		

PO Instructions: MARC, PLEASE HAVE THEM READY WILL ADVISE DELIVERY

11/30/09

Pack Slip No:186146

Ship From: Castle Metals Chicago 3400 North Wolf Road Franklin Park, IL 60131		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Deliver To:	
Date Shipped 01-FEB-10	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier CASTLE_NETWORK K	BOL No 187325	Delivery No 13975294	

Shipment Details				Final Destination Branch -			
Order No 516798	Line No 2	Item No 6857.MO	Description 2.0000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0620/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN (+ .0620/- .0000 IN (GRAIN TO RUN ALONG 7.875")) - ALUMINUM PLATE SAW				
Purchase Order No 8393		Part Number		Ordered Qty 40 PCS		Invoice Qty 40 PCS	Backorder Qty
Details							
Mill	Heat Number 456750A9	Mech ID	PCS 40	Width (IN)	Length (IN)	Shipped Qty (LBS) 397.9	

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

This material has been received and inspected by:	Date:
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AMF 10/02/04

SHIP TO:

A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4149447

SOLD TO:

AM CASTLE & CO- SOLD TO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-15905		WORK PACKAGE:	CUSTOMER PART NUMBER: 6857 A97075-60		SHIP RUN/LOAD ID: 101432/18	GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1075544	LINE ITEM: 1	SHIP DATE: 11-DEC-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE	
WEIGHT SHIPPED: 5732 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 2020668	GAUGE: 2.0000 IN		WIDTH: 48.500 IN	LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
GSS16100/RevG/Amd1

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevE
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 008/RevC
GAMP8 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 456514A9 Cast 198

Drop 21

Ingot 1

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.2 : 73.8 (508 : 509)	63.6 : 84.9 (439 : 447)	11.6 : 11.8

(ASTM E1004)

Conductivity %IACS :	41.2 Min	41.7 Max
(MS/M) :	23.9 Min	24.2 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.21	1.5	0.03	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.05

Amk
10/02/04

**KAISER
ALUMINUM**Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number
4149447

Lot: 456750A9 Cast 193

Drop 20

Ingot 1

(ASTM E8/B667)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.1 : 73.7 (504 : 508)	62.7 : 83.4 (432 : 437)	11.9 : 12.1

(ASTM E1004)

Conductivity %IACS :	41.8 Min	42.2 Max
(MS/M) :	24.2 Min	24.5 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.22	1.4	0.02	2.4	0.20	5.7	0.03	0.01	0.01	TOT 0.05

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

7075-T7351 plate 3.001-3.500" thick, if ultrasonically inspected, meets requirements of CMMP025 per SDR
CMMP025-KaiserT-1. 7075-T7351 plate 3.501-5.000" thick, if ultrasonically inspected, meets requirements of CMMP025 per SDR CMMP025-KaiserT-2.

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CASTLE METALS CORP.
DATE RCVD 12/16/08
IAC 6851608
APPROVED BY [Signature]

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DEARS 225.872-1(M). WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DEARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN COMPLIANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW, 18U-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

[Signature]
Bill Poy